



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C250-100
Job Sheet 200685



Part No: C250-100

Job Qty: 3 pcs

Part Name: Side Plate Cover



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/16/19

Job Tracking No:

Due Date: 11/1/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG C250-100 REV:4 IPP REV A 18.02.27 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Machining - Issue SN	3 pcs	11/1/19	11/1/19	0.00	0.00	NV5000 - 1		J.C.L. 19-10-21
							NV5000 - 2		
110	NV5000 - 1	3 pcs	11/1/19	11/1/19	1.00	4.50	NV5000 - 1		
							NV5000 - 1 - B4B		
							NV5000 - 2		
							NV5000 - 2 - B4B		J.C.L. 19-10-21
120	QC 2	3 pcs	11/1/19	11/1/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		J.C.L. 19-10-21
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S224399



Part: C250-100

Job No: 200685

Serial No/Batch: S224399

Revision:

Inspector:

Exp Date:

Instructions:

Date: 10/21/19

130 QC 8	3 pcs	11/1/19	0.00 0.00	QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	END 19/11/01
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
150 Outsource - 4 - Anodize	3 pcs	11/1/19		GRO002-VC	10 2019-11-04
160 Packaging 2-1 - Receive - B4B	3 pcs	11/1/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	

NOV 13 2019

170 QC 6	3 pcs	11/1/19	0.00 0.00	Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 9	DAS
				QC 6 - 68	NOV 13 2019 68
				QC 6 - 61	9-89
				QC 6 - 40	
175 Small Fab - 2 - B4B	3 pcs	11/1/19	0.00 0.75	QC 6 - 81	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
180 QC 5	3 pcs	11/1/19	0.00 0.00	Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	AP 2019 -11-25
				Small Fab - 8 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	DAS
				QC 5 - 68	NOV 25 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
185 Packaging 3-1 - Stock - B4B	3 pcs	11/1/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	3 pcs	11/1/19	0.00 0.00	QC 21 - SA - 21	DAS 21 NOV 25 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) 1-Machine as per folio FB958 FOLIO REV: AA DWG

Descriptions: REV: 4 2-Debur

120 - (QC2- Inspect parts off machine FAI/FAIB) Engrave S/N Using Marktronic engraver. See note 1 for location.

130 - (QC8- Inspect parts - second check)

150 - -Issue P/O to ATG: 44998 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required

160 - (Receive & Inspect for Damage & Mat'l Certs)

170 - (QC6- All purchased or subcontracted products)

175 - (Small Fab) -Laser Etch, white as per dwg.

180 - (QC5- Inspect part completeness to step on W/O)

185 - (Identify as per dwg & Stock Location: GA) 203F

190 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6S2.250X13.500	6061-T6 Sheet 2.250" Thick x 13.500" Wide cut to size: 16.750"	3 Ea (1 ea)	100-Machining - Issue SN	5066 847

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Machining - Issue SN	M6061T6S2.250X13.500	3	11	0

Part Specifications	
Specifications could not be found.	

DART AEROSPACE LTD		Work Order: 200 685
Description: Side Plate Cover		Part Number: CLSD-100
Inspection Dwg: CLSD	Rev: 4	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.36	± 0.00	16.360	✓		Caliper	A 1000
13.15	± 0.016	13.150	✓		"	
2.020	± 0.005	2.019	✓		Mic.	JCL-03
1.060	± 0.004 ± 0.000	1.060	✓		Caliper	JCL-08
1.188	± 0.004 ± 0.000	1.188	✓			
Ø 0.689	± 0.002 ± 0.000	0.688	✓		Mic.	JCL-01
L Ø 0.915	± 0.010 ± 0.001	.915	✓		Caliper	JCL-08
± 1.155	± 0.003 ± 0.000	1.156	✓			
L Ø 0.415	± 0.010 ± 0.001	0.415	✓			
± 0.085	± 0.005	0.088	✓			
-9.717	± 0.005	-9.7166	✓		NV-Saw-2	
2.207	± 0.005	2.2066	✓		"	
Ø 0.750	± 0.005 ± 0.001	.752	✓		Caliper	JCL-08
Ø .156	± 0.005 ± 0.001	.156	✓			
Ø .323	± 0.006 ± 0.001	.323	✓			
± 1.125	± 0.005	1.120	✓			
Ø 0.9358	± 0.005 ± 0.000	-9358	✓		Bore Gauge	
L Ø 1.290	± 0.012 ± 0.001	1.290	✓		Caliper	JCL-08
± 1.145	± 0.003 ± 0.000	1.145	✓			
Ø .500	± 0.006 ± 0.001	.501	✓			
10-32 UNF	2B	C.K.	✓		Go NV-60	
Ø 0.201	± 0.003 ± 0.001	.201	✓		Caliper	JCL-08
± .625	± 0.005	.625	✓			
Ø 1.001	± 0.006 ± 0.001	1.000	✓		Mic.	JCL-01
L Ø 1.165	± 0.012 ± 0.001	1.165	✓		Caliper	JCL-08
± 1.145	± 0.003 ± 0.000	1.145	✓			
-1.111	± 0.005	-1.1107	✓		NV-Saw-2	
7.831	± 0.005	7.8306	✓		"	
Ø 1.801	± 0.006 ± 0.001	1.800	✓		Bore Gauge	
L Ø 1.728	± 0.012 ± 0.001	1.728	✓		Caliper	JCL-08
± 1.145	± 0.003 ± 0.000	1.145	✓			
Ø 0.6244	± 0.0001 ± 0.0000	0.6246	✓		Bore Gauge	JCL-01

Measured by: JC-L	Checked by: [Signature]	QC Inspector:
Date: 19-07-25	Date: 19/11/01	Date:

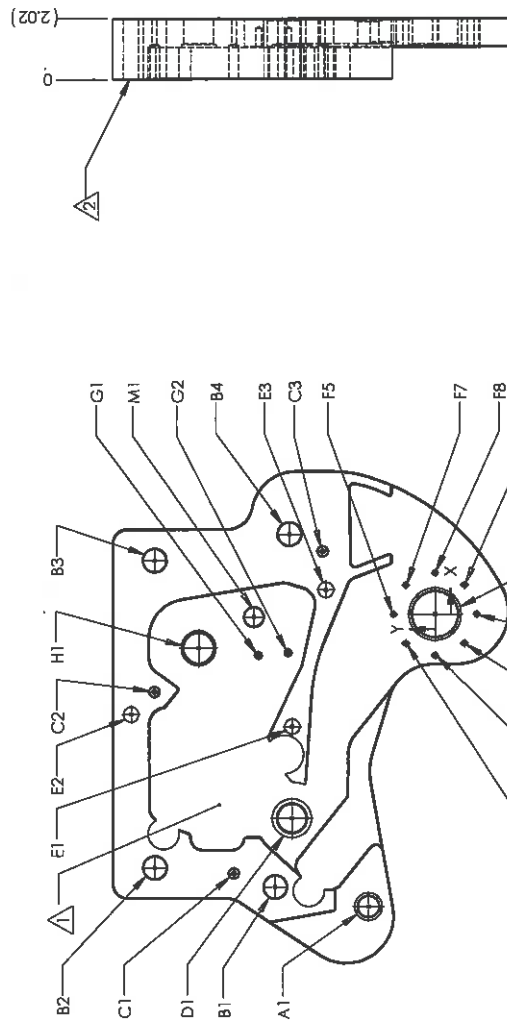
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

Drawings are the property of the company and shall remain the property of the company. No part of this drawing may be reproduced or used in any manner without the written permission of the company.

TAG	X LOC	Y LOC	SIZE
A1	-9.717	2.207	$\phi .689^{+.000}_{-.002}$ THRU ALL 2X $\phi .03 \times 45^{\circ}$ [] $\phi .915 \pm 1.155^{+.003}_{-.000}$ [] $\phi .915 \pm .085$ FAR SIDE
B1	-9.055	5.274	
B2	-8.407	9.299	$\phi .750$ THRU ALL 2X $\phi .03 \times 45^{\circ}$
B3	1.793	9.299	
B4	2.659	4.796	
C1	-8.600	6.656	$\phi .156$ THRU $\phi .323 \pm 1.125$ $\phi .02 \times 45^{\circ}$ NEAR SIDE
C2	-2.560	9.310	
C3	2.088	3.700	
D1	-6.763	4.721	$\phi .9363$ THRU ALL $\phi .9358$ $\phi .04 \times 45^{\circ}$ NEAR SIDE [] $\phi .1290 \pm 1.145^{+.003}_{-.000}$
E1	-3.712	4.709	
E2	-3.307	10.093	$\phi .500$ THRU ALL
E3	.817	3.592	
F1	-1.368	.000	
F2	-9.67	-9.67	
F3	-9.67	.967	
F4	.000	-1.368	
F5	.000	1.368	
F6	.967	-9.67	
F7	.967	.967	
F8	1.368	-9.000	
G1	-1.356	5.828	
G2	-1.269	4.843	$\phi .201 \pm .625$ $\phi .02 \times 45^{\circ}$
H1	-1.111	7.831	$\phi .1001^{+.000}_{-.001}$ THRU ALL $\phi .03 \times 45^{\circ}$ NEAR SIDE $\phi .04 \times 45^{\circ}$ FAR SIDE [] $\phi .1165 \pm 1.145^{+.003}_{-.000}$
K1	.000	.000	$\phi .1501^{+.000}_{-.001}$ THRU ALL $\phi .03 \times 45^{\circ}$ NEAR SIDE [] $\phi .1728 \pm 1.145^{+.003}_{-.000}$
M1	-0.81	5.980	$\phi .6248$ THRU ALL $\phi .03 \times 45^{\circ}$ NEAR SIDE

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		AS DRAWN BY APICAL	6/12/2013	CJR	JAG
2		CHD M1 HOLE CHAMFER WAS .03 X 15° TO .03 X 45°	8/20/2013	CJR	JAG
3	140728	CHD HOLE WAS .03 X 15° TO .03 X 45°	8/14/2014	DPD	RW
4	150309	CHD HOLE WAS .03 X 15° TO .03 X 45°	9/16/2015	DPD	JAG



NOTE:
 1. MACHINE ENGRAVE BATCH NUMBER.
 2. HOLE ∇ CALLED FROM THIS SURFACE.

PART	
SIDE PLATE COVER	
DATE	6/13/2011
SCALE	1:4
SHEET 1 OF 2	

ASSY QTY	ASSY	B/O	Part #	UNIT QTY	Description	Material	8/C INFORMATION OR SPECIFICATIONS
			C250-100	1	SIDE PLATE COVER	6061	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044998



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044998

PO Date: 11/4/19

Due Date: 11/12/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-05

Items

Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200686	C250-200	C250-200 Rev 3	Side Plate Housing -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	11/12/19	3 pcs	0 pcs	3 pcs	\$58.50/pcs	\$175.50
2	200685	C250-100	C250-100 Rev 4	Side Plate Cover -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	11/12/19	3 pcs	0 pcs	3 pcs	\$58.50/pcs	\$175.50
Grand Total:												\$351.00

Guerin



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044998



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/5/19 1:13 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(023817-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

023817 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
08-Nov-2019		Jigar Patel				POHB044998				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description, pièce(s)			CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ N/C Qty	Qté Scrap/	À venir/ Back Order
1	C250-200 Rev.	C250-200 01-ANO-BLACK [ANODIZE BLACK] AS PER IAW MIL-A-8625F TYPE - 2, CLASS - 2 WATER SEALANT			ANODIZE CH	3	3	0	0	0
2	C250-100 Rev.	C250-100 01-ANO-BLACK [ANODIZE BLACK] AS PER IAW MIL-A-8625F TYPE - 2, CLASS - 2 WATER SEALANT			ANODIZE CH	3	3	0	0	0

RECEIVED
NOV 12 2019
DART AEROSPACE LTD.

DAS
68
9-89

RECEIVED
 NOV 12 2019
 DART AEROSPACE LTD.

DART
 68
 9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.